Slip July K

Work Order ID 85737

June-14-12 1:55:53 PM

85737

Page 1

Item ID: D350-607-547 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Utility-Basket **Start Date:** 14/06/2012 **Start Qty:** 1.00 Cust Item ID: **Required Date:** 28/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: MLJ Date: $\frac{12}{06}/\frac{4}{14}$ Tooling: Approvals: Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D350-607-3 Α 100 0.00 DOCUMENT CONTROL *100* DC Memo Document Control Photocopy bluefile & type labels per PPPD350-607-547 CHG 140 Pick Kit 0.00 *140* Packaging 0.00 Memo Packaging 150 QC4-100% Inspect kits for completeness 0.00 *150* Memo Quality Control

)

Work Order ID 85737 Page 2 June-14-12 1:55:53 PM Item ID: D350-607-547 Accept *N900040100* Setup Start **Revision ID:** Item Name: Heli-Utility-Basket Start Oty: 1.00 **Start Date:** 14/06/2012 Cust Item ID: **Required Date:** 28/06/2012 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: **Approvals:** Date: ____ Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Number Stamp **Run Hours** Code Oty 160 0.00 Packaging *160* Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP D350-607-547 Location: 170 QC21- Final Inspection - Work Order Release 0.00 MUJ 12107/11 MUJ 1407/11 *170*

0.00

Memo

QC

Quality Control

										DQA	: Da	te:	
NCR: Ye	s / No				WORK ORDER NON-	·CO	NFOR	MANCE / UP	DATE			_	
							,			QA Closed	: Da	te:	
Work Order	:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
Part No NCR No					Rework Scrap Use-as-is Work Order Update		-	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		od. Eng. Coor. ore/Packaging Supplier Other		Engineering Quality
Root				Descr	iption of work order update	Τ	Initial	Act	tion	Sign &		T	
Cause	Date	Step	Qty		or Non-conformance	Cł	nief Eng	Descr	ription	Date	Verification	n l	QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized													
Landing (Gear				Hardware F.	AUL	T CATE						
	Bending P Centre No Cracks Crushed/C Inspection Other Positioned Ripples on Torque Wa Turning Se Wave/Twis	Crimp at E Strip in 1 Wrong Inner Be aves in Exequence	tric to O/ Bending Tube Ind Itrusion		Breaking Missing Size/Length Spinning Threading Wrong Drill Holes Misaligned Ovalized Over/Undersized Too Many		Finish Inspectic Inspectic Instructic	Short ntation/Data on Incomplete on Unqualified ons Incomplete/Unres/Tooling rect		Maintenand Mislabeled Off-Set Orientation I Out of Calibr Out of Seque Outside Dime Over/Under Part Lost Part Moved Raw Materia	Misread ration ence ensions tolerance	S T W	et-up upplier emperature/Cure Veld Vrong Stock Pulled
H:/FORMS/Quality	Assurance\ap	proved QA/	NCRWO Re	v F				<u> </u>		May Wateria	1		

Picklist Print

June-14-12 1:55:56 PM

Work Order ID: 85737

Parent Item: D350-607-547

Parent Item Name: Heli-Utility-Basket

85737

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC

REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	- Unit of Measure	Qty on Hand	Qty per Kit	 Total Otv	Qty Issued	Date Issued	Status
<u></u>	D350-607-511 HOW *D350-607-Quick Release Basket Mounti	²-511*	Manufactured	No			140	Each	3.0000	**				
	Quick Release Basket Would	ing installation			Location		Loc C	<u>Oty</u>	Loc Code			_/		

IPP

			_			230 0000	
			PK13		3		
			85131		1		
			85132		I		
			85133		1		
D2690-6	Manufactured	No		140	Each	12.0000	
> *D2690-6* Lanyard Assembly						:	ţ
			Location	Loc	c Oty	Loc Code	

				ST014			12	
	/				83360		12	
/	D3912-041	Manufactured	No			140	Each	0.0000
_	>*D3912-041*							
	Eyebolt Receiver Assembly							
	D4032-043	Manufactured	No			140	Each	0.0000
W.	*\ <u>\</u> \4\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\							
"	Short Basket Assembly, Light Lid (350)							
	D40853	Manufactured	No			140	Each	6.0000
>	*D4085-3*							
	Placard, Instructions							

Location Loc Qty Loc Code ST092 83657



										DQA:	Date	:
NCR:	res / No)			WORK ORDER NON	-CO	NFOR	MANCE / UPDA	TE			
	-								-	QA Closed:	Date	: :
Work Orde	er:				DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS	
	lo				Rework Scrap Use-as-is			Machining noforming	Crosstube Small Fab Finishing		d. Eng. Coor. re/Packaging Supplier	Engineering Quality
NCR	lo				Work Order Update			Large Fab C	Composite]	Other	
Root Cause	Date	Step	Qty	Desc	cription of work order update or Non-conformance	1	Initial nief Eng	Action Descripti		Sign & Date	Verification	QC Inspector
Doc/Data equip/Tooling Operator												
Viaterial Offset/Setup												
Other										i .		
rocess								•				
upplier						1						
raining						1						
nauthorized												
						FAUL	T CATE	ORY		!		<u> </u>
Landin	g Gear		_		Hardware			General				
	· · · · ·	g Passes Be		-	Breaking		Burrs			Maintenand	ce [Set-up
Ĺ		Not Concer	ntric to (D/S	Missing		Contami	nation		Mislabeled		Supplier
	Cracks			L	Size/Length		Cut Too	Short		Off-Set		Temperature/Cure
-	—	I/Crimp at	_		Spinning		Docume	ntation/Data		Orientation N	Misread	Weld
-	—	on Strip in	Tube		Threading		Finish			Out of Calibra	ation	Wrong Stock Pulled
F	Other			L	Wrong			on incomplete		Out of Seque	nce	-
	 i	ed Wrong			Drill Holes	_		on Unqualified		Outside Dime	ensions	Other
-		on Inner B		<u> </u>	Misaligned			ons Incomplete/Uncle	ear	Over/Under t	olerance	
-		Waves in E	xtrusion	<u> </u>	Ovalized			res/Tooling		Part Lost		
-		Sequence		_	Over/Undersized		Kit Incor	rect	,	Part Moved		
	Wave/T	wist in Tub	e	-	Too Many		Kit Missii	ng		Raw Material	_	

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Work Order ID: 85737

Parent Item:

D350-607-547

Parent Item Name: Heli-Utility-Basket

85737

Location

ST357

D350-607-547

120187

120422

120770

121652

122063

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00



Purchased

No

140

Loc Oty

Each

1,346.000

Loc Code

**



Purchased

Purchased

No

No

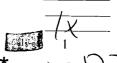
1346 19 2 25 1000 300 140 Each

50.0000





Location Loc Qty Loc Code ST358 120124 l 121146 49 140 30.0000 Each



Location Loc Qty Loc Code ST344 30 120360 5 121166 3 121444 22

Parent Item:

MS17984-C413

June-14-12 1:55:56 PM

Work Order ID: 85737

D350-607-547

Parent Item Name: Heli-Utility-Basket

Purchased

Purchased

Purchased

85737

No

No

No

D350-607-547

Start Date: 14/06/2012

Required Date: 28/06/2012

**

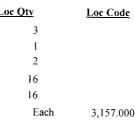
19.0000

Required Qty: 1.00

Start Qty: 1.00

Location	Loc Qty	
ST315	3	3
.114349		i
118612	1	2
ST333	10	5
121350	16	ó
ter	140	Each

140



Each



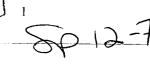
Location	Loc Oty	
ST300	3157	
119075	116	
121011	232	
121444	2509	
121652	300	
	140 Each	



Loc Code

/	MS24665-151
′	*M\$24665-151*
/	Cotter Pin

Location	Loc Qty	Loc Code
ST309	191	
17566	191	





June-14-12 1:55:56 PM

Work Order ID: 85737

Parent Item:

D350-607-547

Parent Item Name: Heli-Utility-Basket

85737 *D350-607-547*

Start Date: 14/06/2012

Required Date: 28/06/2012

Required Qty: 1.00

Start Qty: 1.00

141	*

49C0463R*

Location Loc Qty FG 103691 ST277

405 118709 12 120390 393 140 Each

140

Each

8

Loc Code 636.0000

413.0000

Purchased 149F0432P*

NAS1149C0463R

Purchased

Purchased

No

No

No

Location Loc Qty ST275 636 121350 636 140 Each

Loc Code

828.0000

Location Loc Qty FP001 115358 ST297 827 117735 17 119097 810

Loc Code

June-14-12 1:55:56 PM

Shop Packet Print

Page 5

DQA: Date: NCR: **WORK ORDER NON-CONFORMANCE / UPDATE** Yes / No QA Closed: Date: **DISPOSITION** Work Order: **AGAINST DEPARTMENT/PROCESS** Rework Skid-tube Crosstube Prod. Eng. Coor. Engineering Part No. Scrap Machining Small Fab Rec/Store/Packaging Quality Use-as-is Thermoforming Finishing Supplier NCR No. Work Order Update Large Fab Composite Other Root Description of work order update Initial Action Sign & Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized **FAULT CATEGORY Landing Gear** Hardware General Bending Passes Below Min Breaking Burrs Maintenance Set-up Centre Not Concentric to O/S Missing Contamination Mislabeled Supplier Cracks Size/Length Cut Too Short Off-Set Temperature/Cure Crushed/Crimp at Bending Spinning Documentation/Data Orientation Misread Weld Inspection Strip in Tube Threading **Finish** Out of Calibration Wrong Stock Pulled Other Wrong Inspection Incomplete Out of Sequence **Positioned Wrong Drill Holes** Inspection Unqualified **Outside Dimensions** Other Ripples on Inner Bend Misaligned Instructions Incomplete/Unclear Over/Under tolerance Torque Waves in Extrusion Ovalized Jigs/Fixtures/Tooling Part Lost **Turning Sequence** Over/Undersized Kit Incorrect Part Moved Wave/Twist in Tube Too Many Kit Missing Raw Material

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4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb	
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg	
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in-lb	
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg	
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb	
(Standard Basket)	26.2 kg	± 1.25m	± 32.8 m-kg	3.43 m	89.9 m-kg	
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb	
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg	
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg	

5.0 PARTS LIST

QTY	QTY	QTY	/ QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	-543	-545	-547	-511	-501	TAICI NOMBER	
X				1	-	D350-607-541	HELI-UTILITY-BASKET
	х				·	D350-607-543	HELI-UTILITY-BASKET
		X		 		D350-607-545	HELI-UTILITY-BASKET
			X	<u> </u>		D350-607-547	HELI-UTILITY-BASKET
1	1	1	/ 1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
		,			X	D350-607-501	CONVERSION KIT
						- D. G.	LAANAADD
1	11	1	/ 1		1-1-	-D2690:6	LANYARD
				4	4	D3910-3	X-TUBE LUG
1	1	1	1/1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	- 8	D3984-030	RUBBER EXTRUSION, X-TUBE
1	· ,					D4030-041	LONG BASKET ASSY
	1		l			D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				-D4032-041	SHORT BASKET ASSY
			1_1_			-D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1	1	1	1		1	D4085-3	PLACARD-INSTRUCTIONS
1					1	D4086-200	PLACARD, MAX LOAD
	1				1	D4086-215	PLACARD, MAX LOAD
		1			1	D4086-220	PLACARD, MAX LOAD
			11		1	D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	11		1	D4150-041 Z	ATTACHMENT ARM ASSY
1	1	1	5 1		1	-D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	/1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
			4				
6	6	6	16		6	AN4-13A	BOLT
				16	16	AN4=14A	BOLT
1	11	1	11.	15	1	AN4C15	BOLT
1	1	11	/1-		1	AN310C4	CASTELLATED NUT
1	1	1	71		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	16	16	22	MS21042L4 /	NUT (OR MS21042-4)
1	1	1	> 1		1	MS24665-151 /	_COTTER PIN
2	2	2	2		2	NAS1515H4L	'WASHER
12	12	12	712	32	44	NAS1149F0432P	,WASHER
3	3	3	~ 3		3	NAS1149C0463R	WASHER

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Revision: **A**Date: 10.06.28

Work Order ID 85737

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Page 1

Item ID:

D350-607-547

Accept

*N90004010

Setup Start

Revision ID: Item Name: Start Date:

Heli-Utility-Basket

14/06/2012 Start Qty: 1.00

Cust Item ID:

Customer:

Required Date: 28/06/2012

Reg'd Qty: 1.00

Reference:

Approvals: • Process Plan: MLJ Date: 12/06/14 Tooling:

Qty

SPC (Y/N):

Stop

Insp.

Work Center ID Draw Nbr

Operation Description

Revision Nbr

Set Up/ · Run Hours

Tool # Plan Tool ID Code

Accept Qty

Reject Reject

Number Stamp

D350-607-3

Sequence ID/

100

DOCUMENT CONTROL

Document Control

Memo

0.00

0.00

Photocopy bluefile & type labels per PPPD350-607-547 CHG003

Cd 12.107/09

140

100

Pick Kit

0.00

140

Packaging Packaging

Memo

0.00

150

QC4-100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control